



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2652
Job Sheet 167525



Part No: D2652

Job Qty: 50 ea

Part Name: Bushing



Part Weight: 0 lbs

Job Created: 11/2/17

Due Date: 11/3/17

Type: SOLD

Ship Via:

Status: Scheduled

Priority: High

Job Tracking No:

Created By: Mario Poulin

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		11/2/17	0.00	0.00	Start Up Machining		
100	Hardinge	50 pcs		11/3/17	0.00	1.84	Hardinge		
120	QC	50 pcs		11/3/17	0.00	0.00	QC8		amr ml 12/11/03
130	Packaging	50 pcs		11/3/17	0.00	0.00	Packaging3		
140	QC21-SA	50 Ea		11/3/17	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1-TURN AS PER FOLIO FA252 & DWG D2652

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.500	3	54	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.600inches ± 0.010	0.610 0.590		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.305inches + 0.002 - 0.000	0.307 0.305		
4	Bushing	0.191inches + 0.005 - 0.001	0.196 0.190		
5	Bushing	0.500inches ± 0.010	0.510 0.490		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.000Degrees ± 0.010	20.010 19.990		
8	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010		



S005687



Bushing

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:
Revision:
Operation:
Quantity:
Change No:

D2652

Start up Operation
23

Mfg Date: 11/03/17
Job No: 167525

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>17/11/2</u>		Step #:		QTY Effective :		MRB (QSI042) Approval DAS 12 9-89 <u>17/11/2</u>	
Description Work Order Deviation				Disposition			
<u>303 Stainless is out of stock</u>				<u>Acceptable to use 304 stainless instead of 303 (M304R).</u>			
				Completed By DAS 12 9-89 <u>17/11/2</u>			
				Lead hand / Supervisor Approval Verification <u>[Signature]</u> <u>17/11/02</u>			
				QC / QA Coordinator Approval DAS 38 9-89 NOV 02 2017			

Root Cause				FAULT CATEGORY			
Environment	☐	☐	No Re-verification	Pressure/Forced	☐	☐	Temperature/Cure
Design	☐	☐	Operator	Bending	☐	☐	Set-up
Doc/Data	☐	☐	Offset/Setup	Centre Not Concentric	☐	☐	BOM/Route
Equip/Tooling	☐	☐	Supplier	Cracks	☐	☐	Broken/Damage/Defect
Handling/Pre	☐	☐	Training	Crimp/Kink/Ripple/Wave	☐	☐	Inspection Incomplete/Unqualified
Material	☐	☐	Use for Testing	Cuffs	☐	☐	Contamination
Internal Transport	☐	☐	Poor Information	Crushing	☐	☐	Countersink
Tribal Knowledge	☐	☐	Rushing	Heat Treat	☐	☐	Cut Too Short
LOA	☐	☐	Product Improvement	Wave/Twist in Tube	☐	☐	Instructions Incomplete/Unclear
Substation	☐	☐	Process Improvement	Marks/Chatter	☐	☐	Drill Holes
Past Expiry Date	☐	☐	Manufacturing Process				
Misidentified	☐	☐	Past Due	OTHER : _____			